

Date: Monday, 1/22/2007 7:45:39 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WASHER		
Job Number	: 30344					
Estimate Number	: 10374					
P.O. Number	: N/A			Part Number	: D31375	
This Issue	: 1/22/2007 S.O. No. : N/A			Drawing Number	: D3137 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: E	
Previous Run	: 28632			Material	: N/A	
Written By	:			Due Date	: 1/30/2007	
Checked & Approved By	:			Qty:	30 Um: Each	
Comment	: Est A 04.11.04 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0750	6061-T6 Round Bar .750"	
		Comment: Qty.: 0.0218 f(s)/Unit Total : 0.6552 f(s) 6061-T6 Round Bar 0.75" Material: 6061-T6 Aluminum Bar Ø.750" (QQ-A-200/8 or QQ-A-225/8) (M6061T6R.7500) Batch: M103156	MS 07/01/31
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Machine as per Folio FA471 and Dwg D3137 2-Identify as D3137-5 3-Deburr	MS 07/01/31 40
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MS 07/01/31 40
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	8F 07/01/31 (40)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	YL 07/01/31 X 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:45:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 30344

Part Number: D31375

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 07-01-31

(40)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect work to Step 7

SB 07/01/31

40

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STY10

FINAL INSPECTION/W/O RELEASE

QA took →
27/02/07 \$0

62

9.0 QC21



(40)

Comment: FINAL INSPECTION/W/O RELEASE

SB 07/02/05

Job Completion



11 07-02-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30344
Description: Washer	Part Number:	D3137-5
Inspection Dwg: D3137	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

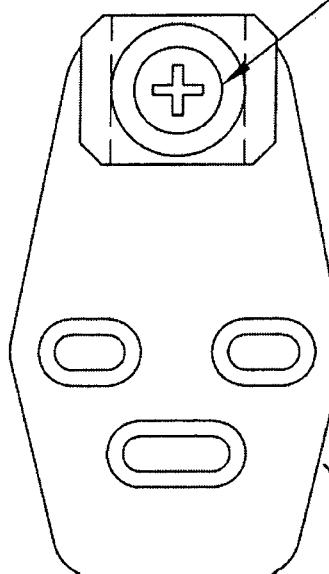
Measured by:	MS	Audited by:	JL	Prototype Approval:	N/A
Date:	07/01/31	Date:	07/01/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	06.03.15	Ø0.650 dimension added; Ø0.660 dimension removed	KJ/JLM	<i>[Signature]</i>

DART

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09 *#*

MS24694-S101 SCREW
D3137-5 WASHER
D3137-3 GUIDE
INSTALL ON SAME SIDE AS C'SINKS
(OPPOSITE SIDE FROM RIDGES)

D3137-1 BRACKET (-041 SHOWN)
OR
D3137-7 BRACKET (-043 SIMILAR)
OR
D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

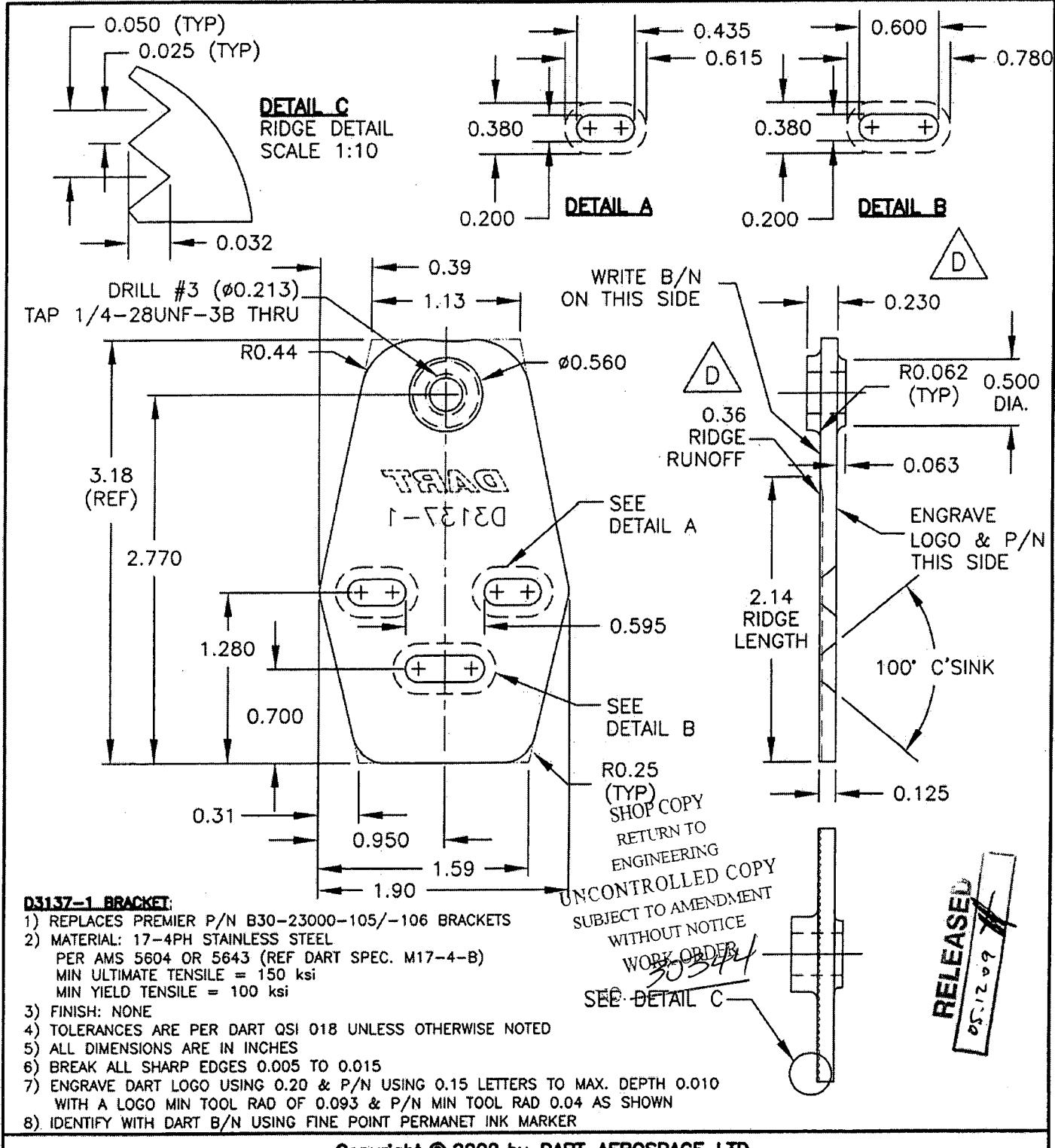
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

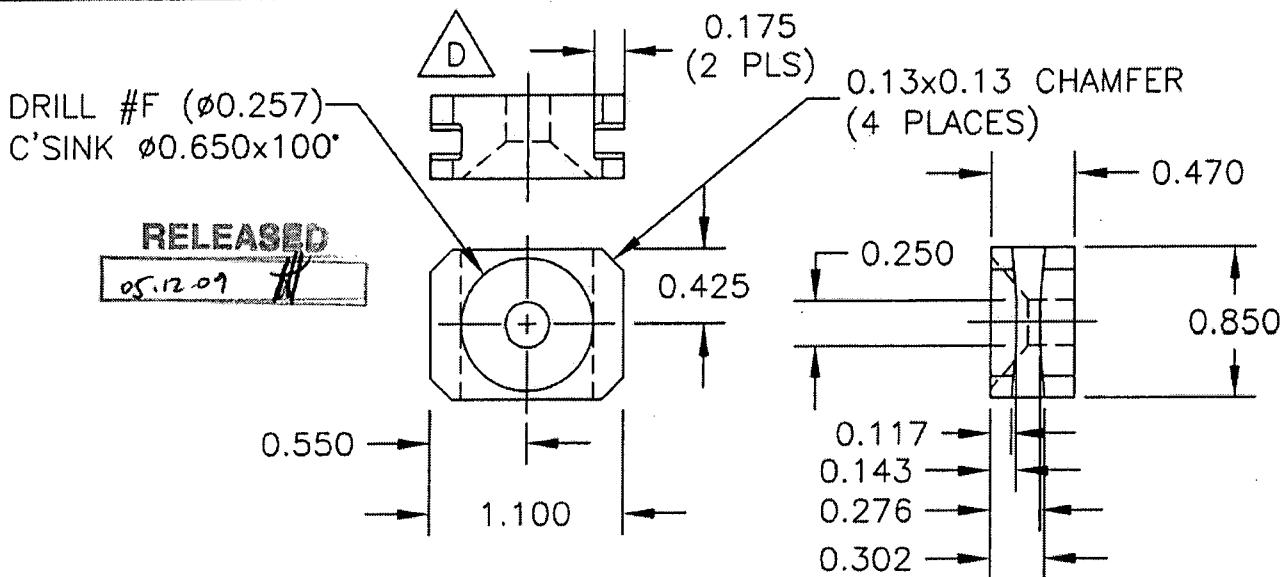


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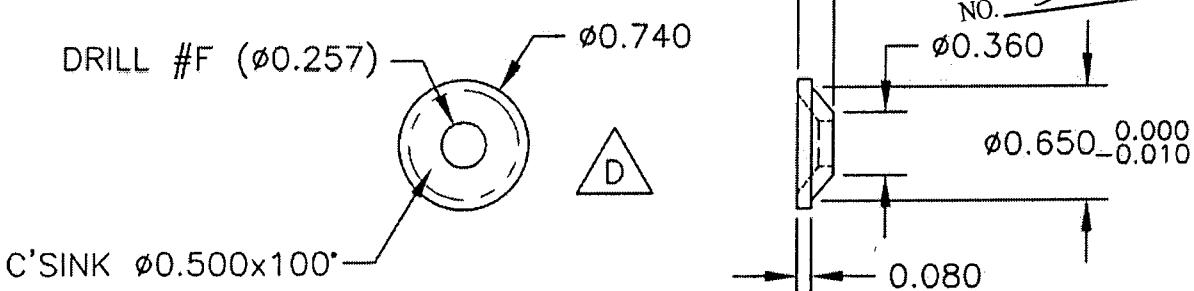
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3137	REV. E SHEET 3 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

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NO. 30344

**D3137-5 WASHER**

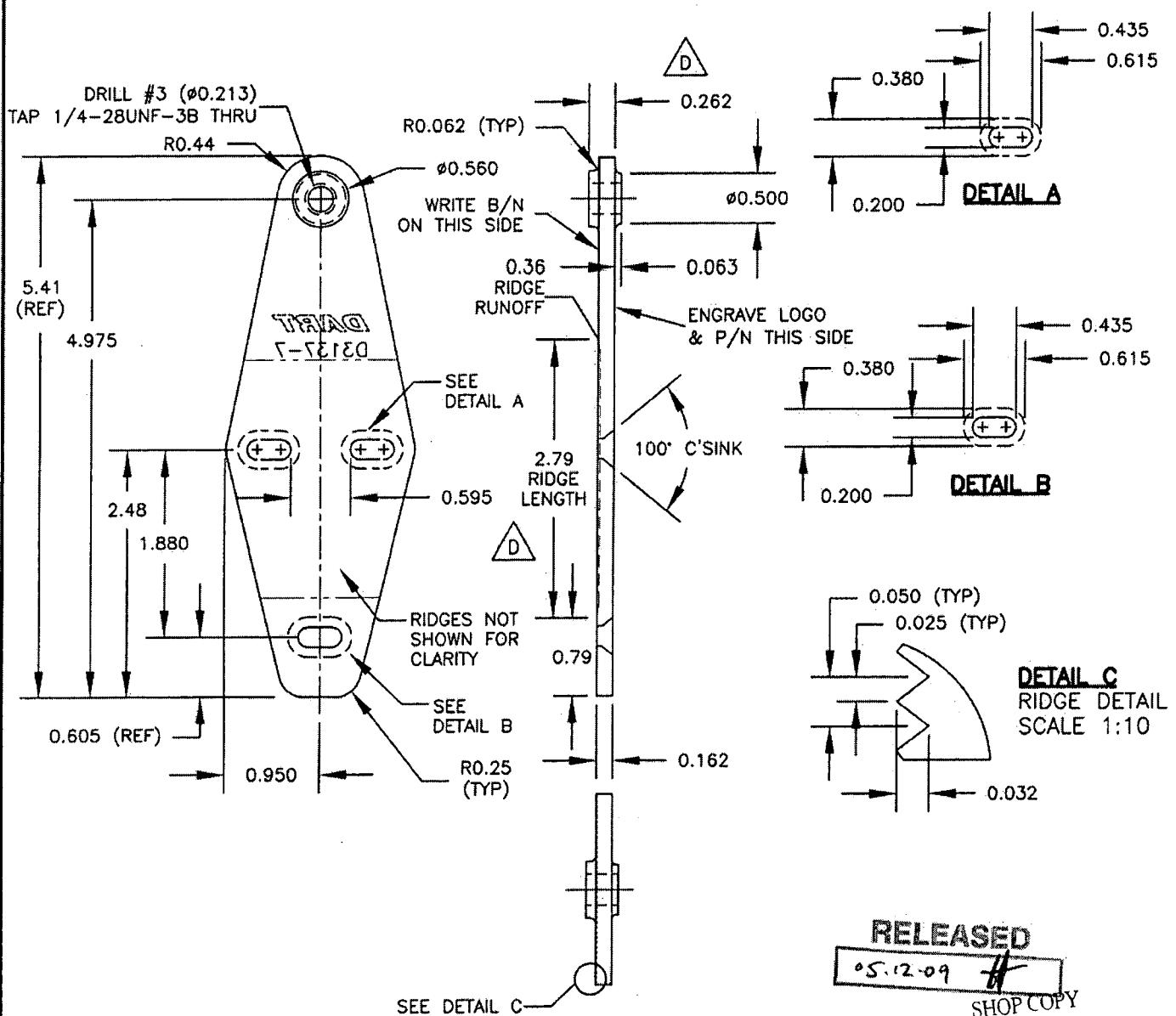
- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3	



03137-7 BRACKET

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
 - 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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05.12.09 A

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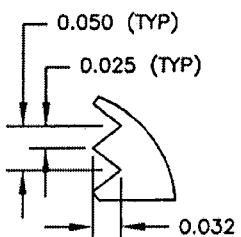
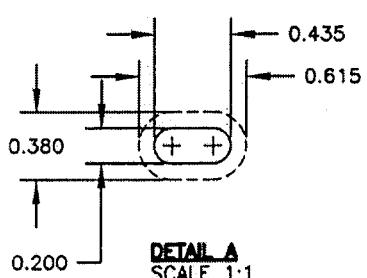
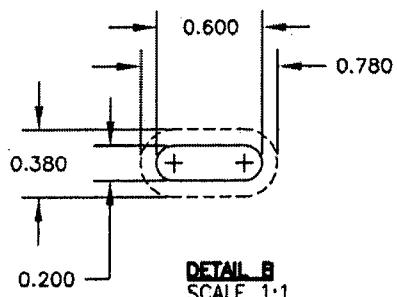
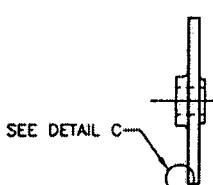
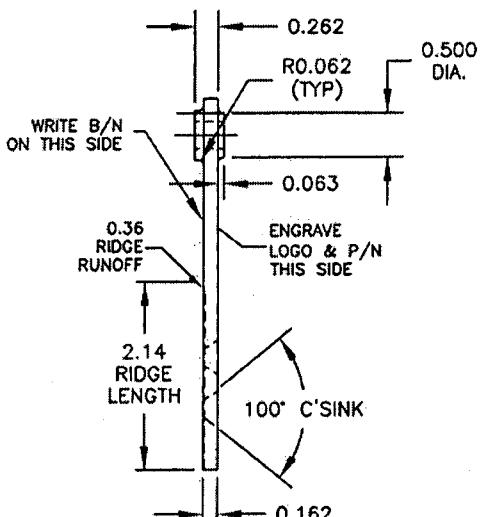
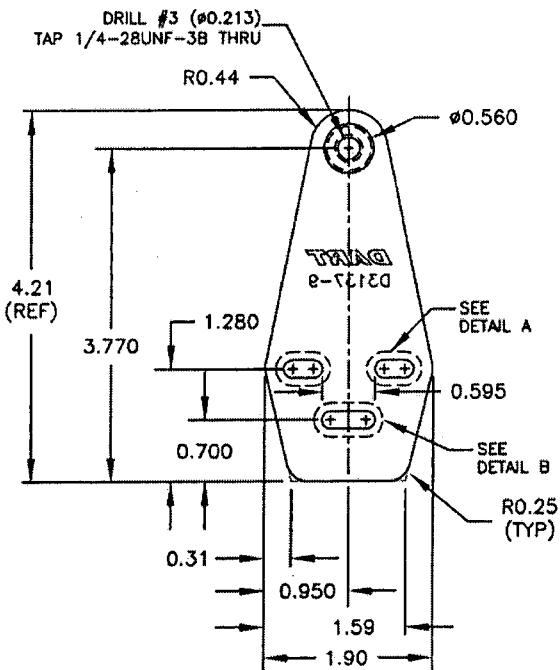
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:2

**DETAIL C**
RIDGE DETAIL
SCALE 1:20**DETAIL A**
SCALE 1:1**DETAIL B**
SCALE 1:1

E

D3137-2 BRACKET:

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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